



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-567-145
Job Sheet 186467



For Stock

Part No: D350-567-145

Job Qty: 2 ea

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DSI9590 REV.G IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

6603

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
90	Start up Operation	2 Ea	11/29/18	11/29/18	0.00	0.00	Start Up Stores/Pkg-2	9-89	NOV 29 2018
110	Packaging	2 pcs	11/29/18	11/29/18	0.00	0.00	Packaging1-3	9-89	NOV 29 2018
120	QC	2 pcs	11/29/18	11/29/18	0.00	0.00	QC4	69	NOV 29 2018
130	Packaging	2 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-1	9-89	NOV 29 2018
135	DC	2 pcs	11/29/18	11/29/18	0.00	0.00	DC	9-89	NOV 29 2018
140	QC21-FG	2 Ea	11/29/18	11/29/18	0.00	0.00	QC21	9-89	NOV 29 2018

Part Op 130 - Identify and pack for shipping as per PPP D350-567-145 Location:FG033
Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-145 CHG001

DAS 21 9-89 NOV 29 2018

FG033

Mbx114

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	10 Ea (5 ea)	90-Start up Operation	5056462
AN525-10R6	Screw	4 Ea (2 ea)	90-Start up Operation	6m137857
AN525-832R7	Screw	4 Ea (2 ea)	90-Start up Operation	5089346
CB200	Acrylic Adhesive, 3.5G	2 pcs (1 ea)	90-Start up Operation	5126623
D3802-1	Window Seal (\$ Per Foot)	4 ft (2 ea)	90-Start up Operation	5164211
D4435-9	Bracket	4 Ea (2 ea)	90-Start up Operation	5124805
D4436-041	Aft Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	508301201 513322
D4441-1	Rubber Seal	4 ft (2 ea)	90-Start up Operation	5092167
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	2 Ea (1 ea)	90-Start up Operation	5077982
D4971-041	T/R Bellcrank Cover Assembly	2 Ea (1 ea)	90-Start up Operation	5102019
D5076-041	Fwd Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5102193
MS21042L06	Nut	14 Ea (7 ea)	90-Start up Operation	5120513
MS21042L08	Nut	4 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	10 Ea (5 ea)	90-Start up Operation	5094592
MS21059L3	Nut Plate	4 Ea (2 ea)	90-Start up Operation	5083547
MS35206-229	Screw	14 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	20 Ea (10 ea)	90-Start up Operation	5107991
NAS1149FN616P	Washer	28 Ea (14 ea)	90-Start up Operation	5087462
NAS1149FN816P	Washer	4 Ea (2 ea)	90-Start up Operation	51131625

Job Allocations

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:15%;">Cross tube</td><td style="width:15%;">Water Jet</td><td style="width:15%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																						
Machining	Small Fab	Prod. Eng. Coord.	Quality																						
Thermoforming	Finishing	Rec/Store/Packaging	Other																						
Large Fab	Composite	Supplier																							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
				Completed By																					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Container No: S133253
 Part: D350-567-145
 Job No: 186467
 Serial No/Batch: S133253
 Revision: G
 Inspector:
 Exp Date:
 Instructions: TC STC SH92-18 Issue Ref: FAAS-TC SH989NE

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Operation
90-Start up Operation

Component Part	Required	Inventory	Allocated
AN3-3A	10	164	0
AN525-10R6	4	117	0
AN525-832R7	4	89	0
CB200	2	20	0
D3802-1	4	143	0
D4435-9	4	20	0
D4436-041	2	1	0
D4441-1	4	539	0
D4730-020-030	2	15	0
D4971-041	2	4	0
D5076-041	2	3	0
MS21042L06	14	166	0
MS21042L08	4	1,240	0
MS21042L3	10	1,880	0
MS21059L3	4	160	0
MS35206-229	14	69	0
NAS1149F0332P	20	1,421	0
NAS1149FN616P	28	165	0
NAS1149FN816P	4	227	0

Part Specifications

Specifications could not be found.

Plex 11/15/18 3:23 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

F

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

REFERENCE ONLY

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

REFERENCE ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE 15.01.12		COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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